

Date: Tuesday, 30/09/2008 11:14:25 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 A/B HIGH GEAR WEB			
Job Number	: 42363						
Estimate Number	: 10455						
P.O. Number	:			Part Number	: D26543		
This Issue	: 30/09/2008	S.O. No. :		Drawing Number	: D2654 REV E1		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /		Type	Drawing Revision	: E1		
Previous Run	: 41973			Material	:		
Written By	:			Due Date	: 07/10/2008		
Checked & Approved By	<u>JL 08.9.30</u>			Qty:	2 Um: Each		
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26005108	Extrusion 'I Beam' thin	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	(2)
		Pick: Qty Part Number Description Batch	JB 8-10-2 1
1	D2600-5	Web	38589
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	

Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

JB 8-10-2

3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	JB 8-10-2
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JB 8-10-2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 30/09/2008 11:14:25 AM
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Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 42363

Part Number: D26543

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



BT 08-10-02 (x2)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L6

JB 8-10-2

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-02

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

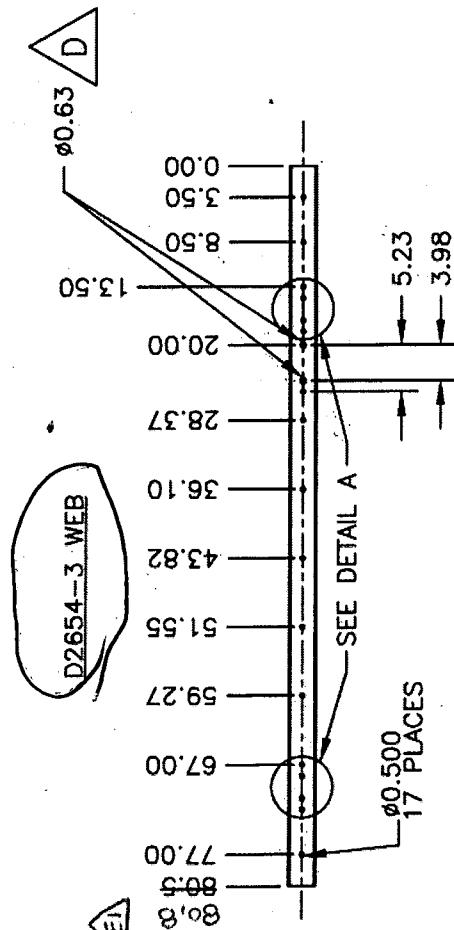
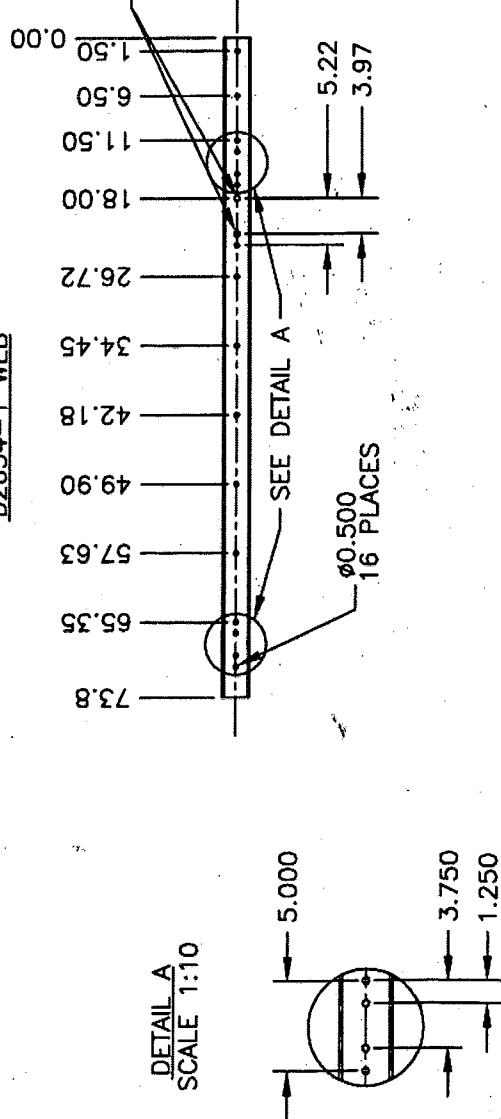
DART

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CHECKED	APPROVED	DRAWING NO. REV. E D2654
DATE		SHEET 1 OF 2
04.05.26		TITLE WEB SCALE 1:20

RELEASED
 04.06.22

A	97.03.25	NEW ISSUE
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438
C	97.10.29	CHANGED HOLE PATTERN
D	98.01.15	GHW HOLES CHANGED TO Ø0.63
E	04.05.26	CHANGE LENGTHS, REFORMAT
E1	04.08.24	PER TOOLING; 80.8 WAS 80.5

D2654-1 WEB



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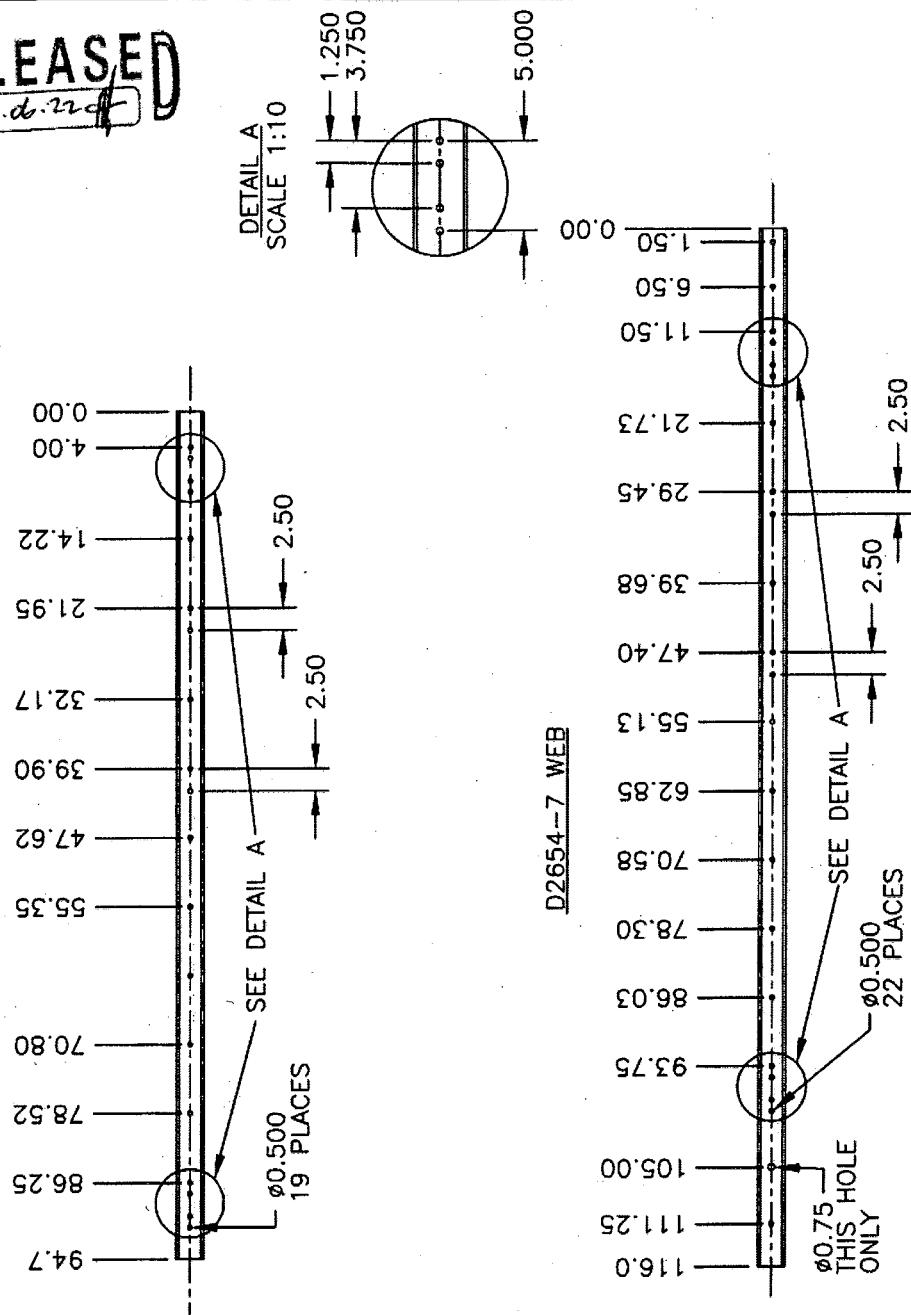
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2 OF 2

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DATE	04.05.26	TITLE WEB SCALE 1:20

RELEASED
04.06.22

D2654-5 WEB



MAKE FROM D2600-7-125 EXTRUSION
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